1. Method to the production of properly matching and surface-precisely, into one another addable body construction units, in particular a vehicle side panel with a door opening and a door therein which can be fastened whereby the outer skin parts become punched both the ambient aluminium also the component which can be fit in common and simultaneous relative position corresponding from an unitary circuit board with one the later fitting in situation, whereby at the location late component which can be fit in into the ambient component to the formation of a fitting in opening from the ambient component a laminar Wands is ripped out, and whereby mounted to the outer skin parts of the into one another addable components reinforcement parts become interiorlateral by welding, characterised in that after the deep drawing of the outer skin parts the reinforcement parts (6, 7) at their destination to the two different, still unseparated continuous outer skin parts (2) of the body construction units (1, 3) mounted become, and that only thereafter the body construction units already ausgesteiften (1, 3) become by outline cuts from each other separate.

2. Process according to claim 1, characterised in that the reinforcement parts (6, 7) of the two body construction units (1, 3) separate in each case manufactured and single to the still unseparated continuous outer skin parts (2) after topographical aligning to it mounted becomes.

3. Process according to claim 1, characterised in that the reinforcement parts (6, 7) as integral mould part (26) at the continuous outer skin parts (2) of the body construction units (1, 3) after topographical aligning to it mounted becomes.

4.Verfahren according to claim 1, characterised in that also the two different reinforcement parts (6, 7) for the ambient and the body construction unit which can be fit in (1, 3) common and simultaneous relative position corresponding from an unitary circuit board with one the later fitting in situation become punched.

5. Process according to claim 1, characterised in that when ripping the body construction unit (3 out) in an unitary procedure a bent section at the new edges of workpiece (36), which can be fit in, made becomes.

6. Process according to claim 1, characterised in that the attachment of the reinforcement parts (6, 7) to the outer skin parts (2) of the body construction units (1, 3) by welding, in particular by laser or electron-beam welding made.

7. Process according to claim 1, characterised in that outline cuts after type of pulling through by transverse to the still continuous outer skin parts (2) a break forming stamp (34) with a separation point (35), diving in into the material situations, or a knife made, whereby the material situations of bottom recess of the gumption outline become from the outside bottom-laterally supported and compressed and whereby the together bordering edges (36) in

the range of the cut edges (41) are break formed to the recessed support (28) over the edges (40).